

G.R.E.Y.

Dart Aerospace Ltd.

Date: Tuesday, 03/03/2009 4:17:06 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : GUIDE
Job Number : 46282	
Estimate Number : 12687	
P.O. Number :	Part Number : D35711
This Issue : 03/03/2009 S.O. No. :	Drawing Number : D3571 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 40222	Material :
Written By :	Due Date : 16/03/2009 Qty: 12 Um: Each
Checked & Approved By : <u>JLD 09.03.04</u>	
Comment : Est Rev:A New Issue 07-02-01 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0750X01500	6061-T6 Bar .750 X 1.50
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Comment: Qty.: 0.2531 f(s)/Unit Total : 3.0366 f(s) /

6061-T6 Bar .75" X 1.5"

Batch: M110167

DTP 09/03/05

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW

Cut blank 2.90 " long

DTP 09/03/05

(12)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA675Rev: AA & Dwg D3571 Rev: A

2-Deburr per dwg D3571

J.F. / DTP 09/03/06

(12)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

DTP 09/03/06

(12)

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

SP 09/03/08 (12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 03/03/2009 4:17:06 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GUIDE

Job Number: 46282

Part Number: D35711

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



X12

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

umo/BK.

09/03/09

7.0

POWDER COATING

POWDER COATING



m 109648

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

X12

START TIME:

14:20

OVEN TEMPERATURE:

320

FINISH TIME:

14:50

umo/BK

09/03/10

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



JA

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-03-76

X12

9.0

PACKAGING 1

PACKAGING RESOURCE #1



X12

Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location:

245A

9/3/10

SEP

10.0

QC21

FINAL INSPECTION/W/O RELEASE



09/03/11

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W 09/03/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 46282
Description: Guide		Part Number: D3571-1
Inspection Dwg: D3571	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

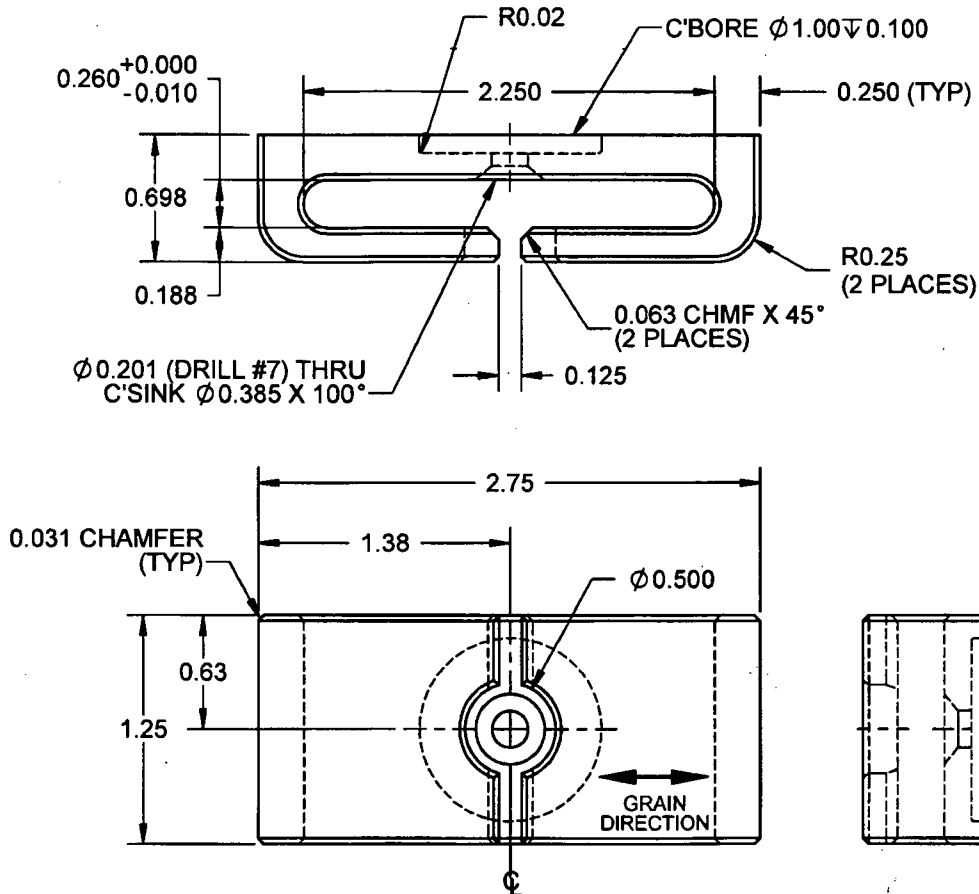
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.698	+/-0.010	0.698	✓			
Ø1.00 Depth 100	+/-0.010	0.998x0.098	✓			
2.75	+/-0.030	2.753	✓			
1.38	+/-0.030	1.374	✓			
1.25	+/-0.030	1.253	✓			
0.63	+/-0.010	0.625	✓			
0.031 chamfer	+/-0.010	0.023	✓			
Ø0.500	+0.006/-0.001	0.501	✓			
Ø0.201	+0.005/-0.001	0.202	✓			
R0.25	+/-0.030	0.250	✓			
0.260	+0.000/-0.010	0.259	✓			
Ø0.385 x 100°	+0.006/-0.001 x 0.5°	0.390x100°	✓			
0.125	+/-0.010	0.125	✓			
2.250	+/-0.010	2.245	✓			
0.250	+/-0.010	0.251	✓			
0.188	+/-0.010	0.186	✓			
0.063 chamfer	+/-0.010	0.063	✓			

Measured by: DJH	Audited by: JS	Prototype Approval:	N/A
Date: 09/03/06	Date: 09/03/08	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.04.16	New Issue	KJ/JLM	JS

DART

DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3571	REV. A SHEET 1 OF 2
DATE 07.01.29	TITLE GUIDE	SCALE 1:1	
REV A	DATE 07.01.29	DESCRIPTION NEW ISSUE	

RELEASED07.04.12 *[Signature]***D3571-1 GUIDE**

SHOP COPY
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ENGINEERING
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *410282*

NOTES:

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR
PER QQ-A-225/8 OR AMS 4117/4128/4115/4116
OR QQ-A-200/8 OR AMS 4160 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3571-1" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) PART IS SYMMETRIC ABOUT ϕ

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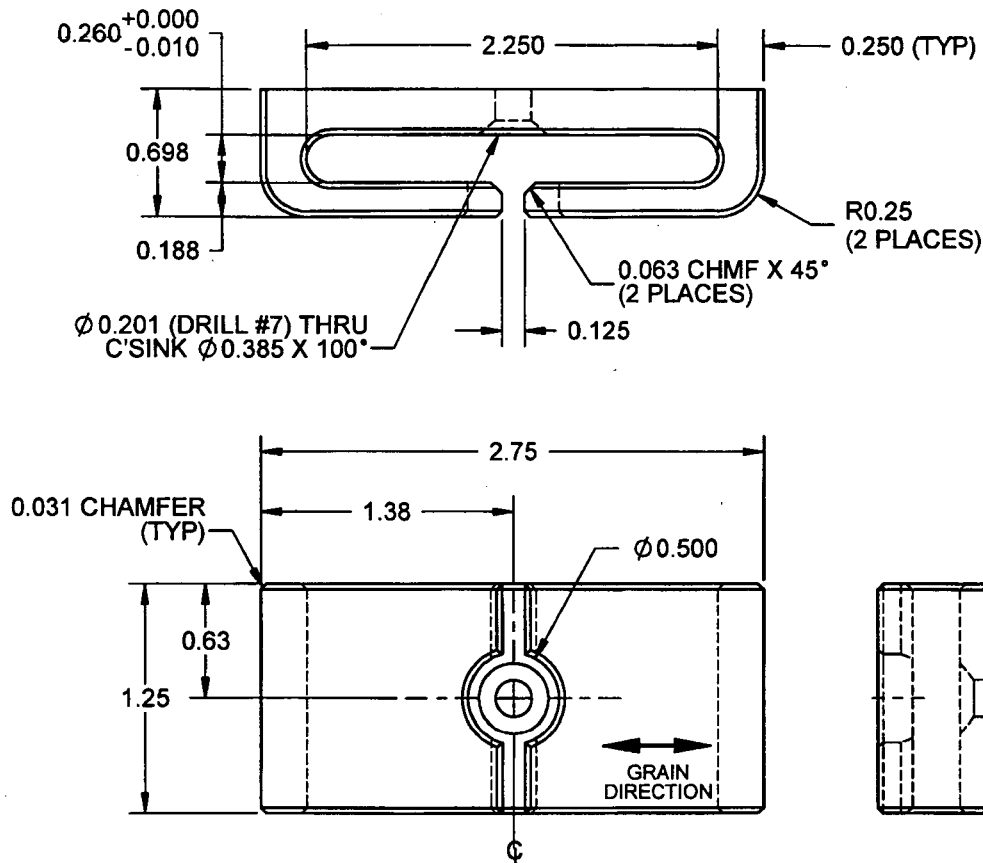
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DATE 07.01.29	TITLE GUIDE		SCALE 1:1

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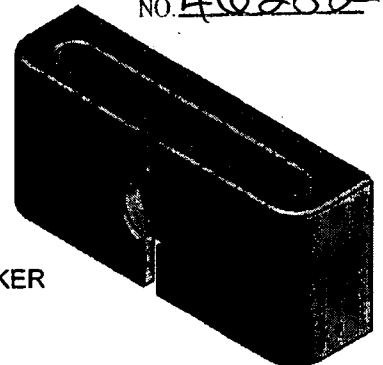
07.04.12

**D3571-3 GUIDE**

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WORK ORDER
NO. 46282

NOTES:

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR
PER QQ-A-225/8 OR AMS 4117/4128/4115/4116
OR QQ-A-200/8 OR AMS 4160 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3571-3" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) PART IS SYMMETRIC ABOUT ϕ



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